



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9711

Job Sheet 207907



Part No: 646.9711

Job Qty: 40 pcs

Part Name: Blade



Part Weight: 0 lbs

Job Created: 3/6/20

Due Date: 3/20/20

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG 646.9700 REV:H IPP REV:A NEW ISSUE 12/09/24 JFS VERIFY BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	40 pcs		3/20/20	0.00	1.25	Bandsaw - 1		J.C.L. 20-03-07
110	HAAS 4 Axis - B4B	40 pcs		3/20/20	0.13	16.67	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
							NV5000 - 1 - B4B		J.C.L. 20-03-12
120	QC 2	40 pcs		3/20/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 20-03-12
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S261580



Part: 646.9711

Job No: 207907

Serial No/Batch: S261580

Revision: Rev H

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/07/20

					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
130	QC 8	40 pcs	3/20/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
140	Outsource - 1 - Heat Treat	40 pcs	3/20/20		MEI001-VC	15
150	Packaging 2-1 - Receive - B4B	40 pcs	3/20/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	

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2020-03-18

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				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155	QC 6	40 pcs	3/20/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
160	Spray Paint - 2 - B4B	40 pcs	3/20/20	0.00 1.33	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
170	QC 14	40 pcs	3/20/20	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51
					QC 14 - 58
					QC 14 - 59
					QC 14 - 9

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				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
				QC 14 - 82	
185	Packaging 3-1 - Stock - B4B	40 pcs	3/20/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B

DA

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					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
190 QC 21 - SA	40 pcs	3/20/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-00

MAY 22 2020

Part Op 100 - (Bandsaw) Cut Blank at 4.625"
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB135
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS
 PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 160 - (Spray Paint / NDT Room) ***THIN COAT OF PRIMER*** PRIME AS PER DWG, SEE NOTE #45265778
 170 - (QC14- Inspect Spray Paint)
 185 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MSTEEL-A2-B0.500X1.250	AISI A2 Tool Steel Bar, 0.500 X 1.250	15.4400 ft (.386 ea)	100-Bandsaw - 1	5257174

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MSTEEL-A2-B0.500X1.250	15	50	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blade	0.340Inches + 0.000 - 0.005	0.340 0.335		.340
2	Blade	0.177Inches + 0.005 - 0.001	0.182 0.176		.177
3	Blade	3.200Inches ± 0.005	3.205 3.195		3.200
4	Blade	0.600Inches ± 0.005	0.605 0.595		.600
5	Blade	0.985Inches ± 0.005	0.990 0.980		.986
6	Blade	2.400Inches ± 0.005	2.405 2.395		2.400
7	Blade	1.200Inches ± 0.005	1.205 1.195		1.200
8	Blade	0.250Inches ± 0.005	0.255 0.245		.250
9	Blade	37.2Angle ± 0.5	37.7 36.7		37
10	Blade	0.290Inches ± 0.010	0.300 0.280		.290
11	Blade	30.0Angle ± 0.5	30.5 29.5		30

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only

Job: _____ Part No.: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Eng. (Non-AW) ☐ Machining ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Rec/Store/Packaging ☐ Finishing ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)			
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabelled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
				QC / QA Coordinator			
				Completed By			
				Lead hand / Supervisor			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046144



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046144

PO Date: 3/18/20

Due Date: 4/7/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2020-03-20

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	207907	646.9711	646.9700 Rev H	Blade : Various STC's (Outsource process - Heat Treat) PO to Metcor: FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS PART ARE MADE FROM AISI A2 TOOL STEEL PLEASE NOTE: DETAIL C OF C REQUIRED	Firmed X40	-	4/7/20	40 pcs	0 pcs	40 pcs	\$5.5833/pcs	\$223.33

MAR 31 2020



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Hawkesbury, ON
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PURCHASE ORDER

POHB046144



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	207906	646.3015	646.3000 Rev NC	Blade : Various STC's FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS As per dwg 646.3000 PART ARE MADE FROM AISI A2 TOOL STEEL DETAIL OF C OF C REQUIRED	Firmed <i>K20</i>	-	4/7/20	20 pcs	0 pcs	20 pcs	\$5.5833/pcs	\$111.67 <i>110</i>
Grand Total:											\$335.00	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A015 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/20/20 4:21 PM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343874	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB046144	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	5 (907)	60 - 61 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
60	20	646.9711 (40) 646.9711 JOB 207907 (20) 646.3015 JOB 207906 2 BC EPS		

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DART AEROSPACE LTD.

COMMENTAIRES / comments

VAC HARDEN 1600°F - 1:40 HRS
DOUBLE TEMPER 400°F - 2:00 HRS

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Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les

METCOR INC.

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BON DE TRAVAIL order	CHARGEMENT load
343874	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

DATE: 2020-03-27

Lucie Desmarais
QA Technician



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
343874	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB046144	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

VAC HARDEN

HARDEN AND TEMPER

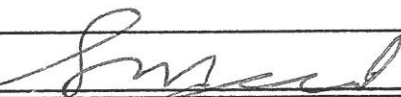
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	5 (907)	60 - 61 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
60	20	646.9711 (40) 646.9711 JOB 207907 (20) 646.3015 JOB 207906 2 BC EPS

30/3/20

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2020-03-22

APPROUVÉ


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METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
343874	1	144596

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT / Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À / Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HBO46144		A2	2020/3/18	CLIENT

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

60 646.9711 ✓ 20,
(40) 646.9711
JOB 207907
(20) 646.3015 ✓
JOB 207906

2 BC EPS

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	2	

CERTIFICAT

EXPÉDIÉ PAR: Shipped by:	
-----------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 60

POIDS EXPÉDIÉ / Weight Shipped : 20,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

Felix: 7701-2060-5774

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MAR 30 2020

DART AEROSPACE LTD.

CERTIFICAT

QUANTITÉ EXPÉDIÉE / Quantity Shipped: 60

POIDS EXPÉDIÉ / Weight Shipped : 20,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2020/03/23